

Work Order ID 82807

82807

Page 1

April-10-12 10:40:29 AM

Item ID: D044-713-014

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Bubble Window, RH

Stop ***NS2***

Start Date: 10/04/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 24/04/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/04/10

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

DSI 9329

B

IIN D044-713

A

** SP*

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefiles and create labels per PPP D044-713-014 & DSI 9329
CHG003

8.2.12/10

MLJ 12-4-17
(2)

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

2x *SP*
12-04-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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April-10-12 10:40:29 AM

Item ID: D044-713-014

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Bubble Window, RH

Stop

NS2

Start Date: 10/04/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 24/04/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120

QC4- 100% Insp kits for completeness

0.00

120

QC

Memo

0.00

8/2/12

(2)

Quality Control

130

Packaging

0.00

130

Packaging

Memo

0.00

Identify and pack for shipping as per PPP D044-713-014

Location:

PPP Rev: C

20

12/4/12

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

12/4/12

mk

12-04-12

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NOTE: Date & initial all entries

Picklist Print

April-10-12 10:40:35 AM

Page 1

Work Order ID: 82807

82807

Parent Item: D044-713-014

D044-713-014

Parent Item Name: Bubble Window, RH

Start Date: 10/04/2012

Required Date: 24/04/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev: A05.03.22 New issue KJ/JLM
IPP Rev: A06-07-03 As per DSI 9329 JLM
IPP Rev: C 08-07-30 chg qty DD verified by: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
DT8720		Manufactured	No			110	Each	0.0000	1	2			
DT8720									**	2x SP			
template													
D2126		Manufactured	No			110	f	437.7668	7.525	15.84211			
D2126									**	SP			
Seal													
<div> <div>Location</div> <div>ST405</div> <div>57106</div> <div>68336</div> <div>76094</div> </div> <div> <div>Loc Qty</div> <div>437.76679</div> <div>4</div> <div>8.76679</div> <div>425</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> <div></div> </div>													
(D2126-0903) cut 1 at 90.30"										15.84			
D3269-2		Manufactured	No			110	Each	2.0000	1				
D3269-2									**	SP			
Bubble Window, RH													
<div> <div>Location</div> <div>ST176</div> <div>75258</div> </div> <div> <div>Loc Qty</div> <div>2</div> <div>2</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
D3312-1		Manufactured	No			110	Each	2.0000	1	2			
D3312-1									**	2x			
Placard										SP 12-04-17			
<div> <div>Location</div> <div>ST038</div> <div>64937</div> </div> <div> <div>Loc Qty</div> <div>2</div> <div>2</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
										2x			

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART

DESIGN <i>OP</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>OP</i>	APPROVED <i>[Signature]</i>	DRAWING NO. DSI 9329	RÉV. B SHEET 1 OF 1
DATE 06.06.26	TITLE BUBBLE WINDOW INSTALL MOD.		SCALE NTS
A	06.04.25	NEW ISSUE	
B	06.06.26	CHG TO EFFECTIVE AFTER CHG 002	

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D044-713 REV. A

REF. CANADIAN STC: SH05-13 ISSUE 1

REF. FAA STC: SR02088NY

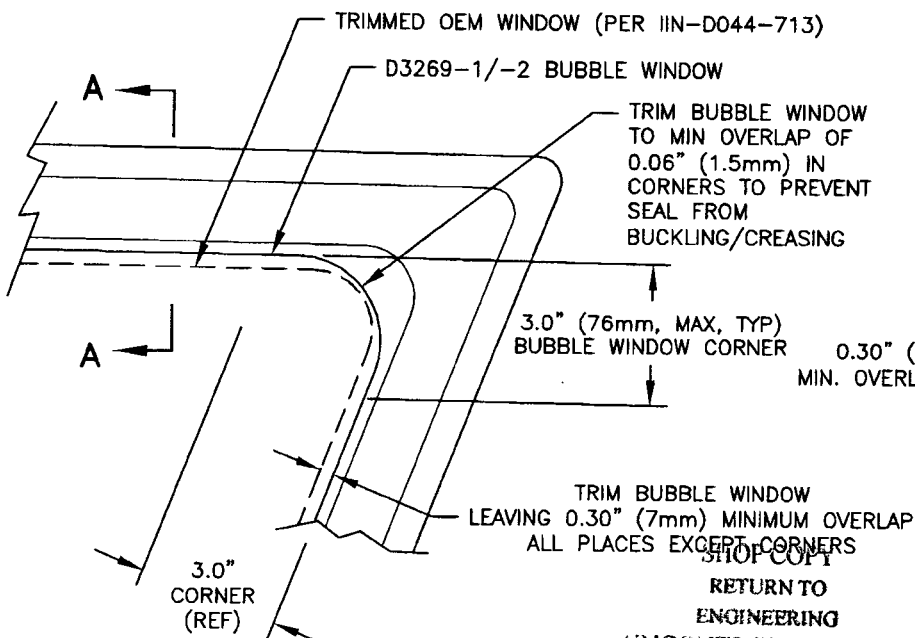
PURPOSE: For the D044-713-013/-014 kits supplied after CHG 002, the D3267-1/-2 bubble windows have been supplied untrimmed to allow for easier installation in the field. The installer must trim the windows in accordance with these instructions prior to installation.

PROCEDURE:

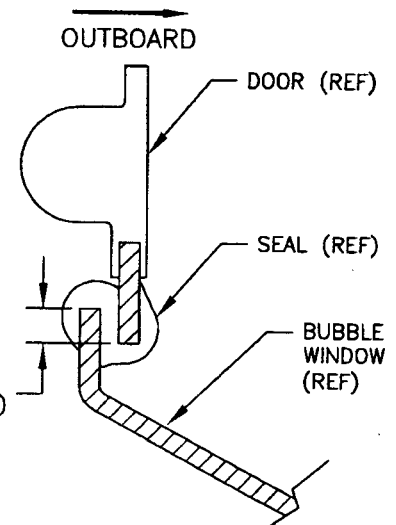
- 1) Modify the R44 crew door per items 3.2.1 and 3.2.2 of Installation Instructions IIN-D044-713 Rev.A.
- 2) Fit and trim the D3269-1/-2 Bubble Window to match the cutout in the door as follows: The bubble window must be a minimum of 0.30" (7mm) larger than the cutout in the OEM window as shown in the figure below. However, in the corners of the window, it is acceptable to trim a 0.06" minimum overlap (1.5mm) to help prevent the D2126-0903 Seal from buckling/creasing in the corners. The edge of the bubble window must be deburred to a smooth finish.
- 3) Continue installing the bubble window per items 3.2.3 through 3.2.5 of the installation instructions.

FIGURE 1

LOOKING AT INSIDE CORNER OF DOOR

**SECTION A-A**

(NOT TO SCALE)



UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 82807 *MLJ*
12/04/10

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 06.06.26
CERT. NO.: SH05-13
ISSUE NO.: 1

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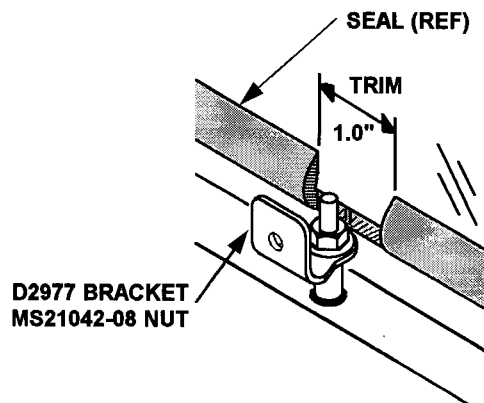


FIGURE 4 – D044-713-015 Passenger Door Window Kit – Tab Installation

4.0 WEIGHT AND BALANCE

The following are the net weight increase associated with the modification kits.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D044-713-011 Crew Door Window Kit	1.5 lb 0.68 kg	±24 in ±0.61 m	±36 in-lb ±0.43 m-k-g	66 in 1.68 m	99 in-lb 1.1 m-k-g
D044-713-013 Bubble Window Kit, LH	2.5 lb 1.1 kg	-28 in -0.71 m	-70 in-lb -0.78 m-k-g	66 in 1.68 m	165 in-lb 1.8 m-k-g
D044-713-014 Bubble Window Kit, RH	2.5 lb 1.1 kg	+28 in +0.71 m	+70 in-lb +0.78 m-k-g	66 in 1.68 m	165 in-lb 1.8 m-k-g
D044-713-015 Passenger Door Window Kit	1.2 lb 0.54 kg	±23 in ±0.58 m	±28 in-lb ±0.31 m-k-g	83 in 2.11 m	100 in-lb 1.1 m-k-g

5.0 PARTS LIST

Qty -011	Qty -013	Qty -014	Qty -015	Part Number	Description
X				D044-713-011	CREW DOOR WINDOW KIT, (FITS LH & RH)
	X			D044-713-013	BUBBLE WINDOW KIT, LH
		X		D044-713-014	BUBBLE WINDOW KIT, RH
			X	D044-713-015	PASSENGER DOOR WINDOW KIT, (FITS LH & RH)
			1	D2126-0720	SEAL
1	1	1		D2126-0903	SEAL
	1			D3269-1	BUBBLE WINDOW, LH
		1		D3269-2	BUBBLE WINDOW, RH
1				D3277-1	WINDOW
			1	D3279-1	WINDOW
	1	1		D3312-1	PLACARD
			1	D2977	BRACKET
			1	MS21042-08	NUT
*1	*1	*1		DT8720	D044-713-011/-013/-014 CUTTING TEMPLATE (FWD DOOR)
			*1	DT8721	D044-713-015 CUTTING TEMPLATE (AFT DOOR)

* Not to be installed. Cutting template only.